

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027800**Date Inspected:** 19-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

OBG 11E

This QAI observed the joining by welding of a butt joint in 2.5" pipe located at OBG 11E Panel Point 98 by welder Damian Llanos utilizing the Shield Metal Arc (SMAW) Process. The welding was being accomplished using E6010 for the root and hot pass; and E7018 for the cap or final pass.

Welding Parameters were being monitored by QC Inspector Steve Jensen and verified by this QAI at random intervals. All parameters verified by this QAI met the requirements of Welding Procedure Specification 1-12-1.

QAI observed the welding of a butt joint in 2.5" pipe at OBG11E Panel Point 97.5 by welder Damian Llanos utilizing the Shield Metal Arc (SMAW) Process. The welding was being accomplished using E6010 for the root and hot pass; and E7018 for the cap or final pass.

Welding Parameters were being monitored by QC Inspector Steve Jensen and verified by this QAI at random intervals. All parameters verified by this QAI met the requirements of Welding Procedure Specification 1-12-1.

QAI observed the welding of a butt joint in 2.5" pipe at OBG11E Panel Point 96.5 by welder Damian Llanos

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utilizing the Shield Metal Arc (SMAW) Process. The welding was being accomplished using E6010 for the root and hot pass; and E7018 for the cap or final pass.

Welding Parameters were being monitored by QC Inspector Steve Jensen and verified by this QAI at random intervals. All parameters verified by this QAI met the requirements of Welding Procedure Specification 1-12-1.

OBG W13-W14 Splice West Drop-in

This QAI observed the preheating of deck splice 13W-14W-W2.8. The QC recorded and QAI verified preheat was being accomplished by utilization of an induction heating blanket. A constant preheat of 250F was randomly verified by this QAI throughout the shift.

QAI observed the back welding of deck splice 13W-14W-W2.8 by welder Jeremy Doleman in the 4G position utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes.



Summary of Conversations:

There were general conversations with Quality Control Inspector Steve Jensen, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By: Daggett, Matt

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer